

Date: Tuesday, 05/08/2008 2:31:20 PM
 User: Julie Lecocq

Process Sheet

88 08/08/26

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : BACK LEG
 Job Number : 40989 - 2
 Estimate Number : 13378
 P.O. Number :
 This Issue : 05/08/2008 S.O. No. :
 Prsht Rev. : NC Part Number : D37721
 Drawing Number : D3772 REVA
 Project Number : N/A
 First Issue : 11 Type : SMALL /MED FAB Drawing Revision : A
 Previous Run : 40317 Material :
 Due Date : 21/08/2008 Qty: 36 Um: Each
 Written By :
 Checked & Approved By : JUD 08.8.05
 Comment : Est Rev:A 08-06-18 rev.A as per dwg DD verified by:EC

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

M304TR1250W125

304 RD Tube 1.250 x .125w



Comment: Qty.: 2.3100 f(s)/Unit Total : 83.1600 f(s)

304 RD Tube 1.250 x .125w

BATCH: M108432

SAD 08/08/13

2.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-cut tube to length as per dwg D3772

2-drill holes thru on both ends of tube as per dwg D3772

3- deburr

4-bend tube as per dwg D3772

SAD 08/08/13

J.F. 08/08/26

D.D. 08/08/26

FF 08/08/26

3.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

4.0

PACKAGING 1

PACKAGING RESOURCE #1







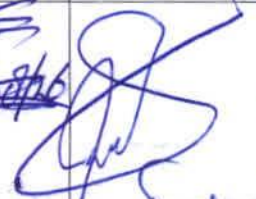
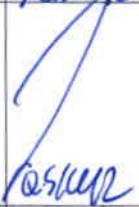
Comment: PACKAGING RESOURCE #1

Identify and Stock
Location GA

SAD 08/08/26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3772-1 PAR #: NA Fault Category: Prod/Process material NCR: Yes No DQA: D Date: 2008/26
 QA: N/C Closed: D Date: 2008/28

NCR: 40989		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/25	22	During Drilling inspection holes are not drilled off. They Do not allow bolts to pass through. Through. Qty 24 (24)		Scrap and Destroy and no Repl/ce Qty 24 <u>24</u>	FF 08/08/26			S 08/25
		24 holes were Drilled off. wrong location (not on the C/L) when tube was rotated. Set up error.		- Parts to be machined on Mass.	FF 08/26/06			S 08/26

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BACK LEG

Job Number: 40989

Part Number: D37721

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC21

FINAL INSPECTION/W/O RELEASE



08/08/27

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



mf 08-08-27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

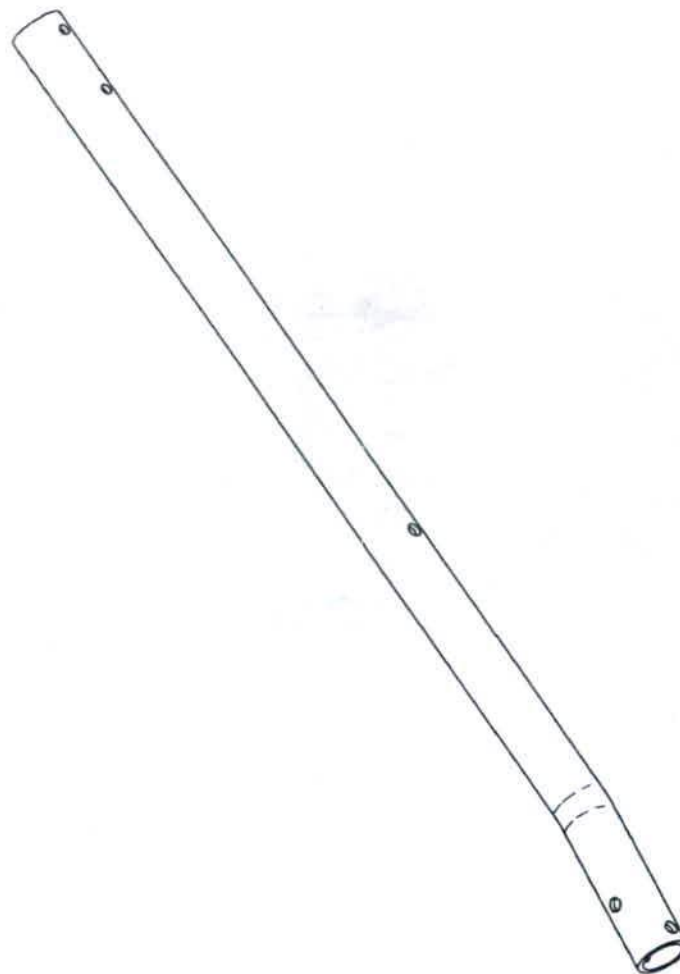
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date:
User:



D3772-1 BACK LEG

NOTES:

- 1) MATERIAL: AISI 304/316 SS TUBING 1.25" OD X 0.125" WALL (REF DART SPEC M304TR1.25W.125)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 3.26 lbs

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 40789

RELEASED
08.06.12

A	NEW ISSUE	HS	08.06.03
REV.	DESCRIPTION	BY	DATE
DESIGN	HS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	HS		
CHECKED	HS	DRAWING NO.	REV. A
MFG. APPR.	HS	D3772	SHEET 1 OF 2
APPROVED	HS	TITLE	SCALE
DE APPR.	HS	BACK LEG	NTS
DATE	08.06.03	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

